

CLAIMS

What is claimed is:

1. A method of manufacturing a container top part (12) forming a cover of a container (11) for solid, paste-like liquid and particulate products, particularly food products, wherein a foil (14) is provided on the container top part (12) and wherein at least the container top part (12) consists of a plastic material, said method comprising the steps of providing an injection mold (15) having a cavity corresponding to said container top part (12), placing said foil (14) into said injection mold (15) and heating said foil (14) to a predetermined temperature before it is contacted by a plastic material injected into said injection mold (15), injecting said plastic material into said injection mold (15) in contact with said heated foil (14) to establish a connection between the container top part (12) and the heated foil (14) in the injection mold (15) and permitting said container top part (12) and the foil (14) connected thereto to jointly cool down so as to form said container top part with said foil joined therewith.

2. A method according to claim 1, wherein, said foil (14) is transferred to said injection mold from a storage location (17) or its location of manufacture (152) and is heated during the transfer from to the injection mold (15).

3. A method according to claim 1, wherein the foil (14) is heated upon placement into the injection mold (15).

4. A method according to claim 1, wherein the foil (14) is so applied to the container top part (12) that, for opening the container bottom part (13) which is closed by the container top part (12), the foil (14) is removable from the container top part (12).

5. A method according claims 1, wherein the container top part (12) consists of polypropylene.

6. A method according to claims 1, wherein the temperature of the injection mold (15) is maintained during the injection procedure of the container top part (12) and its jointure with the foil (14) in the area of 65°C.

7. A method according to claims 2, wherein the foil (14) is transferred into the injection mold (15) by a handling device (18) and the temperature of a handling device (18) is maintained at a temperature in the area of 80°C for heating the foil (14) during its transfer.

8. A method according to claim 8, wherein, during the transfer by the handling device (18), the foil (14) is exposed to hot air.

9. A method according to claim 1, wherein the temperature of the plastic material (16) which forms the container top part is maintained in the range of 230 to 240°C, at which the material is plasticized.

10. A method according to claim 1, wherein said foils (14) are stored at a storage location (17) where they are held available and said storage location is temperature-controlled.